

Date: Monday, 11/08/2008 10:20:24 AM
 User: Linda Lacelle

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BRACKET		
Job Number	: 41083-1				Part Number	: D35921		
Estimate Number	: 12811				Drawing Number	: D3592 REV.B		
P.O. Number	:				Project Number	: N/A		
This Issue	: 11/08/2008 S.O. No. :				Drawing Revision	: B		
Prsht Rev.	: NC				Material	:		
First Issue	: 11/08/2008 Type : SMALL /MED FAB				Due Date	: 25/08/2008 Qty: 40 Um: Each		
Previous Run	: 35331							
Written By	:							
Checked & Approved By	: JUD 08.8-11							
Comment	: Est Rev:A New Issue 07-03.26 ec							

Additional Product

Job Number:



CR206-026

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
		 Comment: Qty.: 0.1460 sf(s)/Unit Total : 5.8380 sf(s) 6061-T6 .125 Sheet Batch: 108659 HB 8-8-13
		Grain must be Along 4.63"**
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3592 Dwg Rev: B HB 8-8-13 Prog Rev: B
		 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 HB 8-8-13
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1
		Form as per Dwg D3592 using DT8949

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3592-1 PAR #: N/A Fault Category: Prod / FB ASS NCR: Yes No DQA: B Date: 08/10/16
 QA: N/C Closed: B Date: 08/10/16

NCR: 41083		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/16	U.0	Parts with the grain direction along the 3.857" length are cracking during welding. R.C: Parts pull during welding along the grain > Process.	J 081016	Sawing parts in accordance with CAK08-026, to try with the grain on a 45°	SB 08/10/16	/	/	/

NOTE: Date & initial all entries

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Drawing Name: BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
08-10-15

Scrap Pkgs
Re Pkgs
AS
Sels/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A~	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41083
Description: Bracket	Part Number:	D3592-1
Inspection Dwg: D3592	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>WB</u>	Audited by:	<u>b</u>	Prototype Approval:	N/A
Date:	<u>8-8-13</u>	Date:	<u>08/08/13</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	AS



DART

DESIGN <i>99</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>99</i>	APPROVED <i>#</i>	DRAWING NO. D3592
DATE 07.05.31		REV. B SHEET 1 OF 1
A 07.01.15		TITLE PLATE
B 07.05.31		SCALE 1:1
		NEW ISSUE
		TOOLING HOLES ADDED



